

Date: Monday, 2/25/2008 7:33:38 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP BRACKET  
Job Number : 37530  
Estimate Number : 13161  
P.O. Number :  
This Issue : 2/25/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D37291  
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3729 U/R  
Previous Run : 37491 Material :  
Due Date : 2/25/2008 Qty: 4 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev: A 08-01-30 new issue DD verified by: EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.0062 f(s)/Unit Total : 4.0249 f(s)

6061T6 aluminium bar 5.00" X .50" thick  
(M6061T6B0500X05000)

Batch:

106747 x 2  
106182 x 2

B 8-2-25

Each

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3729

Dwg Rev: U/R

Prog Rev: U/R

B 8-2-25

2- Deburr if necessary B 8-2-25

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 8-2-25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

B 8-2-25 (4)

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr if necessary

2- grind water jet marks all around bracket smooth

\*\*\* do not grind inside where step extrusion goes \*\*\*

B 8-2-25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1D Date: 08/03/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/07	2	holes for Ribs are too large. RC. repair from water jet	<i>[Signature]</i> 08/03/12	Scrap and Destroy and Replace Qty (x4) B# 106747	<i>[Signature]</i> 08/03/12	<i>[Signature]</i> 08/03/13	<i>[Signature]</i> 08/03/12	<i>[Signature]</i> 08/03/10
08/03/13	2	0.257 holes are too large by 0.010" RC. repair from water jet	AJS 08.03.2	holes are acceptable for this one time only change DFX to cut smaller pilot holes.	<i>[Signature]</i> 08/03/13 AJS 08.03.3	<i>[Signature]</i> 08/03/13	AJS 08.03.13	<i>[Signature]</i> 08/03/13

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 7:33:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP BRACKET

Job Number: 37580

Part Number: D37291

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



ASS

08-03-13

ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

08/03/13

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(5x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

08/03/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08-03-13

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: G1A

MF

08-03-13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/13

Job Completion



08-03-13

POSITIVE RECALL

EFFECTIVE 08-02-25 AUTH L

RELEASED ASS DATE 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 37580
Description: Step Bracket		Part Number: D3729-1
Inspection Dwg: D3729 Rev: U/R		Page 1 of 1

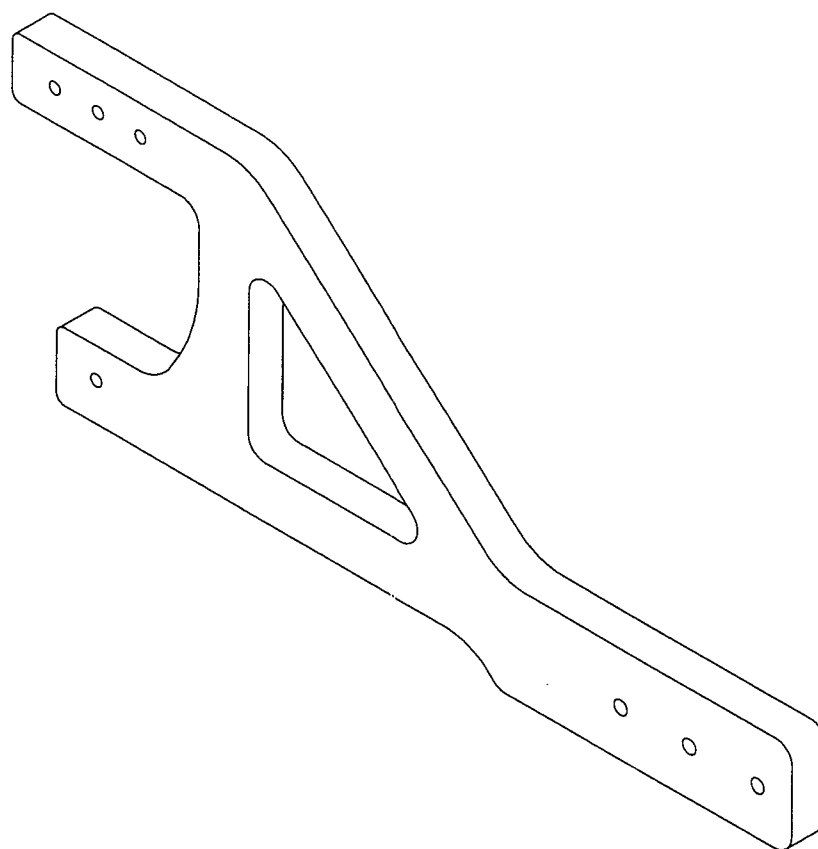
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.257	+0.006-0.001	0.260	✓		VERN	
1.40	+/-0.030	1.397	✓		VERN	
4.38	+/-0.030	4.373	✓		VERN	
0.75	+/-0.030	0.748	✓		VERN	
3.50	+/-0.030	3.50	✓		VERN	
0.750	+/-0.010	0.748	✓		VERN	
0.75	+/-0.030	0.75	✓		VERN	
2.000	+/-0.010	2.010	✓		VERN	
1.000	+/-0.010	1.008	✓		VERN	
0.500	+/-0.010	0.505	✓		VERN	
0.675	+/-0.010	0.665	✓		VERN	
6.13	+/-0.030	6.13	✓		VERN	
6.53	+/-0.030	6.53	✓		VERN	
R0.25	+/-0.030	R0.25	✓		RG	
R0.59	+/-0.030	R0.59	✓		RG	
R0.29	+/-0.030	R0.29	✓		RG	

Measured by: <i>M. M.</i>	Audited by: _____	Prototype Approval: _____
Date: 08 03 12	Date: _____	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3729-1 STEP BRACKET**

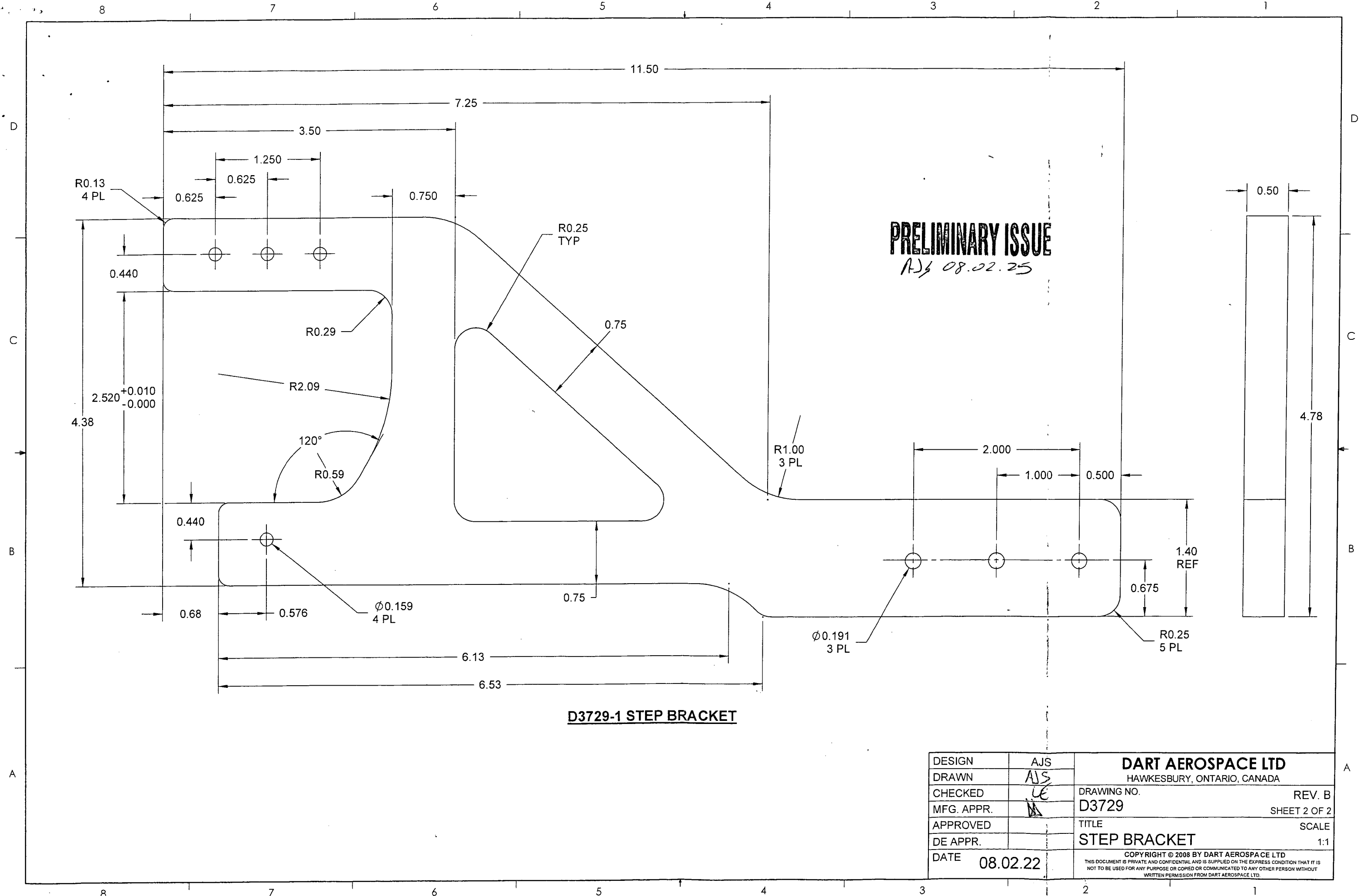
**PRELIMINARY ISSUE**

*AJS 08.02.25*

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)  
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs

B	SHEET 2 ZONE 8C, 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE 7B & 7C, Ø0.159 HOLES ADDED.		AJS	08.02.22
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.	DA	D3729	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		STEP BRACKET	NTS	
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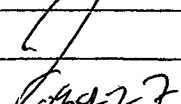


DART AEROSPACE LTD		Work Order: 37580
Description: STEP BRACKET		Part Number: D3729-1
Inspection Dwg: D3729-1 Rev: U/R		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

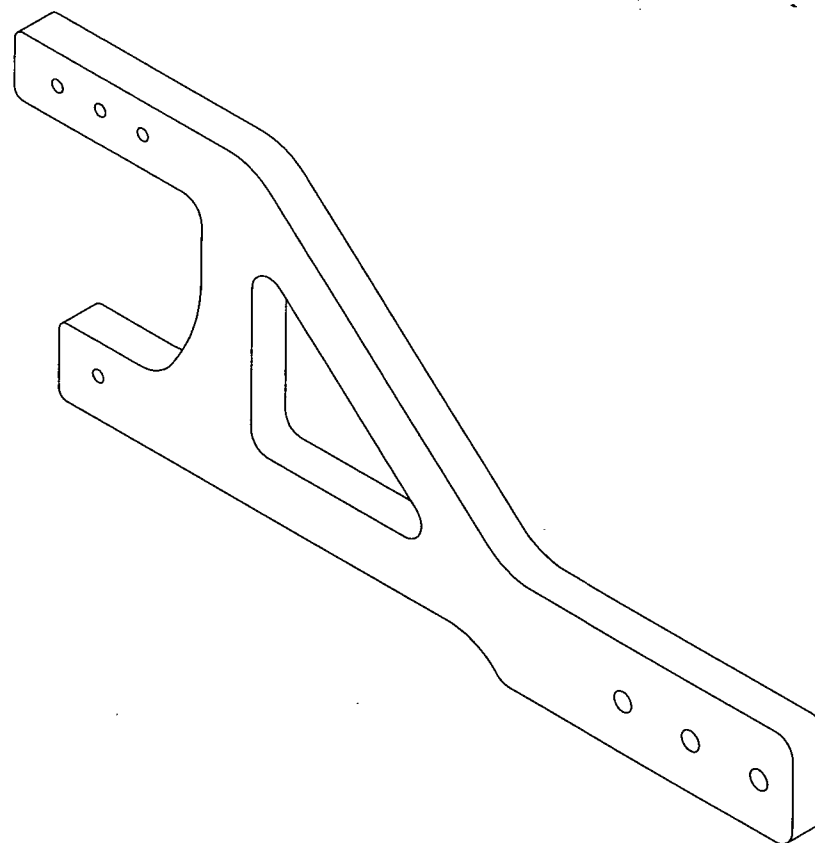
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.194	*			
Ø .159	+ .005 - .001	.162	*			
.440	+/- .010	.440	*			
.625	+/- .010	.626	*			
.625	+/- .010	.627	*			
1.250	+/- .010	1.250	*			
.750	+/- .010	.756	*			
3.50	+/- .030	3.50	*			
4.38	+/- .030	4.39	*			
2.520	+/- .010	2.515	*			
.576	+/- .010	.571	*			
7.25	+/- .030	7.25	*			
11.50	+/- .030	11.50	*			
.675	+/- .010	.675	*			
1.40	+/- .030	1.409	*			
.500	+/- .010	.490	*			
1.000	+/- .010	1.000	*			
2.000	+/- .010	2.002	*			
.50	+/- .030	.495	*			

Measured by: IB	Audited by: 	Prototype Approval:
Date: 8-2-25	Date: 8-2-27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



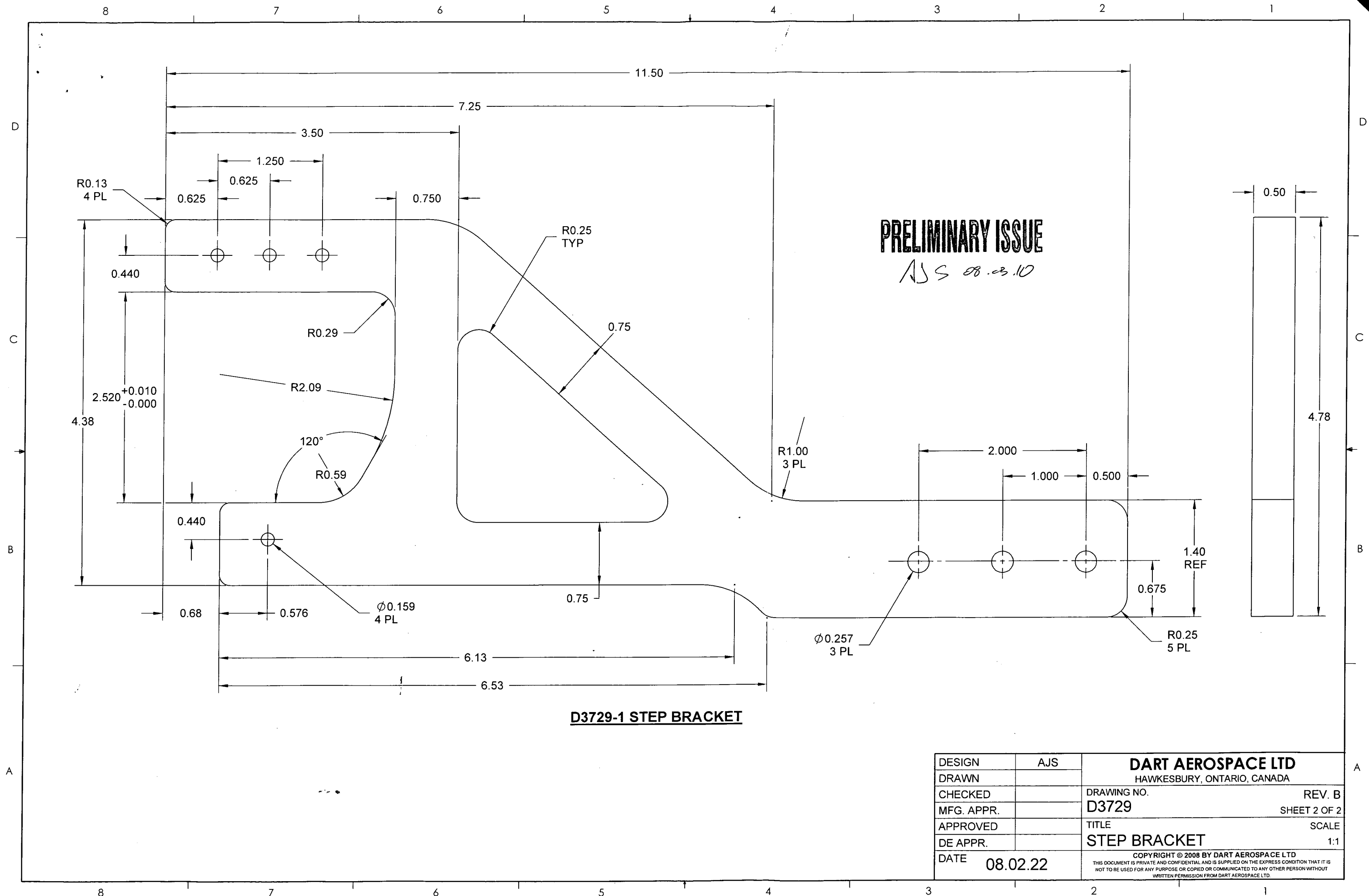


**D3729-1 STEP BRACKET**

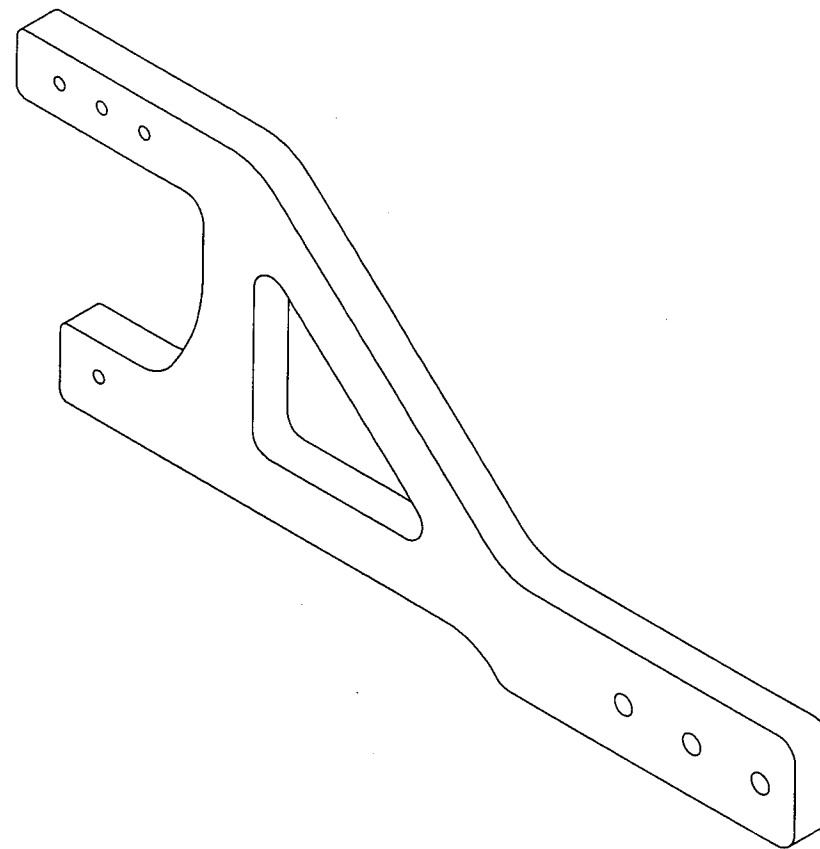
**PRELIMINARY ISSUE**  
*AJS 08.03.10*

- NOTES:**  
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)  
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.99 lbs

B	SHEET 2 ZONE 4B Ø0.257 HOLE WAS Ø0.191, 8C 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE 7B & 7C Ø0.159 HOLES ADDED.	AJS	08.02.22
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3729</b>	SHEET 1 OF 2
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DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3729</b>	SHEET 2 OF 2
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DE APPR.		<b>STEP BRACKET</b>	1:1
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**D3729-1 STEP BRACKET**

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CHECKED	ME	DRAWING NO.	REV. B
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